

Work Order ID 146903-2

Tuesday, May 24, 2016 10:00:36 AM

146903

Page 1

Item ID: D350-615-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GHW Modification, Fits LH or RH

Start Date: 5/17/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 15.00

15

Customer:

Reference:

MAY 25 2016

Approvals: Process Plan: MJS

Date: MAY 25 2016 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-615-041	B
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100 Document Control

0.00

MAY 26 2016

MJS 16-06-07

100

DC Memo Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003

2X

DAS
28
9-89

JUN 07 2016

110

0.00

110

Small Fab Memo Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts***

2

FF

JUN 01 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC Memo Quality Control

(2)

DAS
38
9-89

JUN 01 2016

2016

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146903

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.45				2X	DAS 28 9-89	JUN 07 2016	
Quality Control									
140		0.00							
140									
Packaging	Memo	0.00				2x	DAS 28 9-89	JUN 07 2016	
Packaging	Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PRP D350-615-041 Location :FG023								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	1.50				MLJ		JUN 08 2016	
Quality Control									

MLJ JUN 08 2016

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146903

D350-615-041

Required Date: 5/30/2016

Required Qty: 15.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041		Manufactured	No			110	Each	0.0000 145990	1	15		JUN 01 2016	
D2282-041 T Assembly not pulled → 145997 (13)													
D2282-043		Manufactured	No			110	Each	2.0000	1	15			
D2282-043 Saddle Assembly ** 15													
<u>Location</u> GA <u>Loc Qty</u> 2 <u>Loc Code</u> 145575													
142541 2 _____													
5/16-18-015C		Purchased	No			110	Each	64.0000	3	45			DAS 6 9-89
5/16-18-015C SS Bolt 5/16-181.5"K **													
<u>Location</u> ST583 <u>Loc Qty</u> 64 <u>Loc Code</u> _____													
m134359 64 45													
D3015-3		Manufactured	No			110	Each	109.0000	3	45			
D3015-3 Locknut ** 45													
<u>Location</u> FG <u>Loc Qty</u> 18 <u>Loc Code</u> _____													
95758 8 _____													
96151 10 _____													
ST015 91 _____													
141898 91 45													
MAY 26 2016													

Picklist Print

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Work Order ID: 146903

146903

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 5/17/2016

Required Date: 5/30/2016

Start Qty: 15.00

Required Qty: 15.00

5/16WC

Purchased

No

110

Each

159.0000

12

180

5/16WC

Washer

**

134839 X7

DAS
6
9-89

Location

Loc Qty

Loc Code

ST583

159

m134359

109

m134772

50

123
30

7/16-14-050C

Purchased

No

110

Each

57.0000

1

15

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST584

57

m134349

57

15

D3015-5

Manufactured

No

110

Each

43.0000

1

15

D3015-5

SS Nylock Nut 7/16

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025A

43

141899

43

15

7/16WC

Purchased

No

110

Each

60.0000

2

30

7/16WC

Washer, SS Flat 7/16

**

DAS
6
9-89

Location

Loc Qty

Loc Code

st572

10

120508

10

ST584

50

m134751

50

10

20

MAY 26 2016

MAY 2

Location/Lot Activity

Monday, June 06, 2016 3:18:19 PM

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Criteria :	All Items	All Locations	Lot: 146903	All Transaction Types	All Dates	Report on Locations & Lots				
Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Shipment	D350-615-041 / GHW Modification, Fits LH or RH	Main Warehouse	SO126223	LARO03		15.0000		13.0000		
		FG023			5/30/2016	-10.0000	146903	-10.0000		(\$1,004.97)
		Main Warehouse	SO126374	LARO03		5.0000		3.0000		
		FG023			5/31/2016	-2.0000	146903	-2.0000		(\$200.99)
		Main Warehouse	SO126357	LARO03		1.0000		1.0000		
		FG023			5/31/2016	-1.0000	146903	-1.0000		(\$100.50)
								-13.0000		(\$1,306.47)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Labor Report

Monday, June 06, 2016 3:19:03 PM

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Criteria : All Employees All Departments Work Order ID: 146903 All Items All Product Families All Status All Labor Dates
Grouped by Employee ID Sorted by WO ID

Employee ID	First Name Last Name	Work Order ID	Route Seq ID	Item ID Item Name	Revision Level	Labor Date	Actual Setup Hrs	Setup Hours	Setup Amount	Actual Lab Hrs	Labor Hours	Labor Amount	Nbr Of WOs
FRAN01	Frans Franken	146903	110	D350-615-041 GHW Modification, Fits LH or RH		5/30/2016	0	0	\$0.00	2.05	2.05	\$43.21	1
		146903	110	D350-615-041 GHW Modification, Fits LH or RH		6/1/2016	0	0	\$0.00	0.2667	0.2667	\$5.62	1
Totals :									0	\$0.00	2.3167	\$48.84	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					